REFURB SG371-SG606

SECTION – 1

Engine Bay Pipes and Clamps

Specification

1. **Drain and store existing vehicle coolant (Volvo VCS2 campaign completed only).**
2. **Change all coolant system flexible hoses and replace existing flexible hose clips with constant torque clips (torque to 6 Nm).**

   Change header tank plastic coolant pipe quick connector fittings.

   Inspect Y piece coolant pipe connectors on N/S and O/S of engine bay to ensure brass connectors are fitted. Fit brass connectors if original plastic connectors still fitted.

   Change plastic engine core/blank plug (located behind oil filter housing).

2a. Change all chassis coolant hoses and the 2 hoses front O/S battery box compartment as shown in section 1.2a.

3. **Inspect all engine cooling system steel pipes, pipe clamps, clips, rubbers, brackets and replace/repair if necessary (as shown sections 1.2, 1.7 and 1.10 below).**
4. **Change the cooling system radiator (latest Volvo part no.) and ensure all rubber cushions and mountings are present on installation.**
5. **Change electric fan pack. Torque electric fan retaining bolts when fitting new fan. Inspect electric fan wiring loom and repair/replace where necessary.**
6. **Change engine compartment cooling fan.**
7. **Change all gearbox cooling system flexible hoses and replace existing hose clips with constant torque clips. Ensure all pipe bracketry present and correct (torque to 6 Nm).**
8. **Fit upgraded compressor and installation kit if identified on BAC check list.**

   Change compressor coolant pipes as detailed and ensure pipe clipping arrangements are in place.

   Fit new compressor oil seal and dust cover. Inspect compressor pulley and replace if any indication of wear on the seal seat area.

9. **Change engine thermostat and seals.**

10. **Replace all heating system flexible hoses in the engine compartment and replace existing clips with suitable constant torque clips. Inspect all heater pipe clips & brackets in the engine compartment. Replace existing or missing pipe "P" clips or brackets where necessary.**

11. **Check/Test and repair where necessary coolant level indicator system. Replace rubber grommets on coolant level warning indicator.**

12. **Refill vehicle coolant (See note 1).**

13. **Perform coolant pressure test of the vehicle cooling system to ensure there are no coolant leaks.**

<u>Note 1</u> – Coolant supplied by BAC for use when necessary.

<u>Note 2</u> – All repairs must be undertaken in accordance with the Vehicle Manufacture's (Volvo) parts and service instructions as detailed on the Volvo IMPACT online parts and service website.

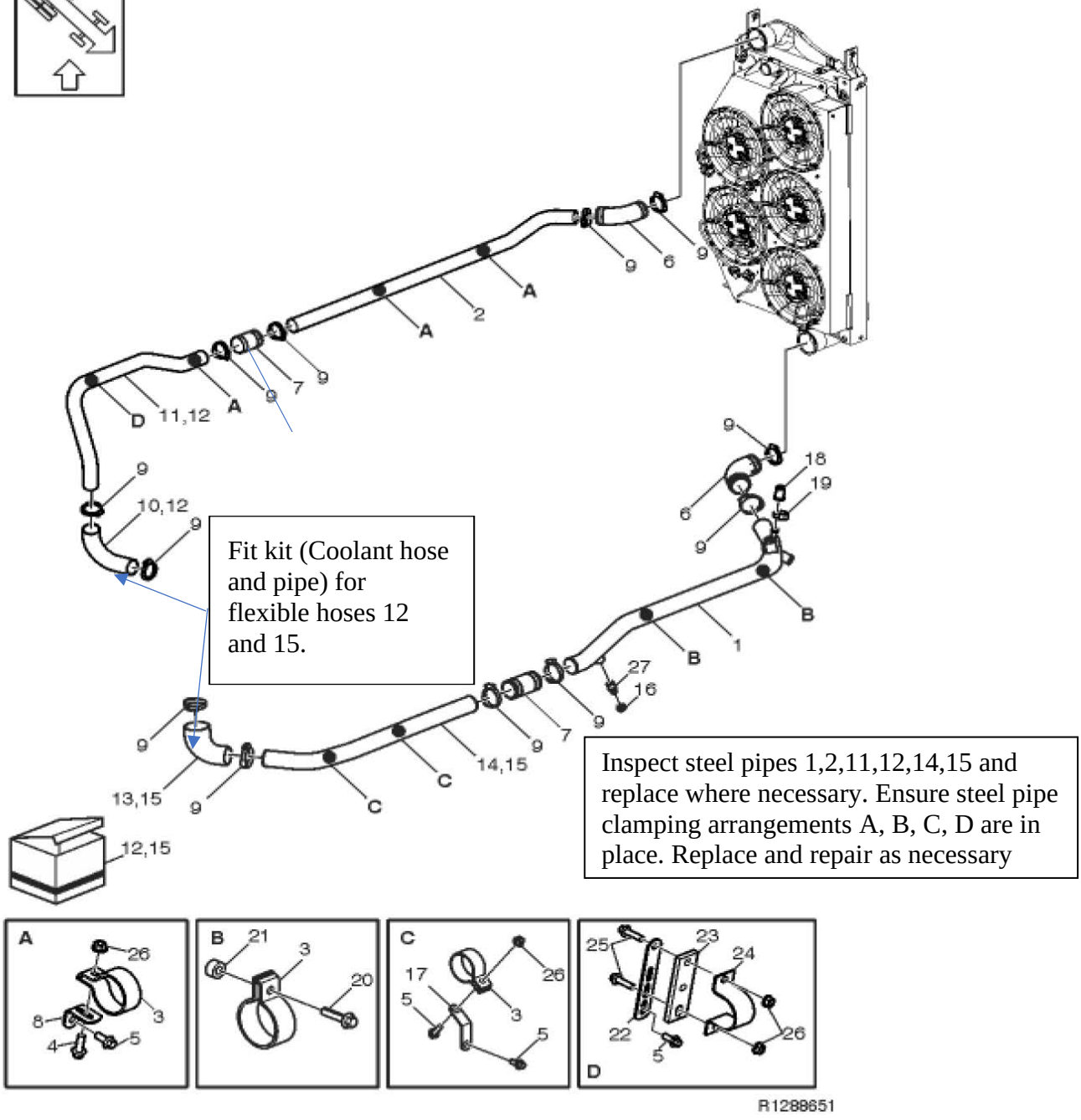
All the relevant Volvo tools as detailed in these service instructions must be used to undertake the service instructions as detailed on Volvo IMPACT.

<u>Note 3</u> - It is advised that engine mountings are inspected and replaced where necessary before clipping of coolant pipes is undertaken.

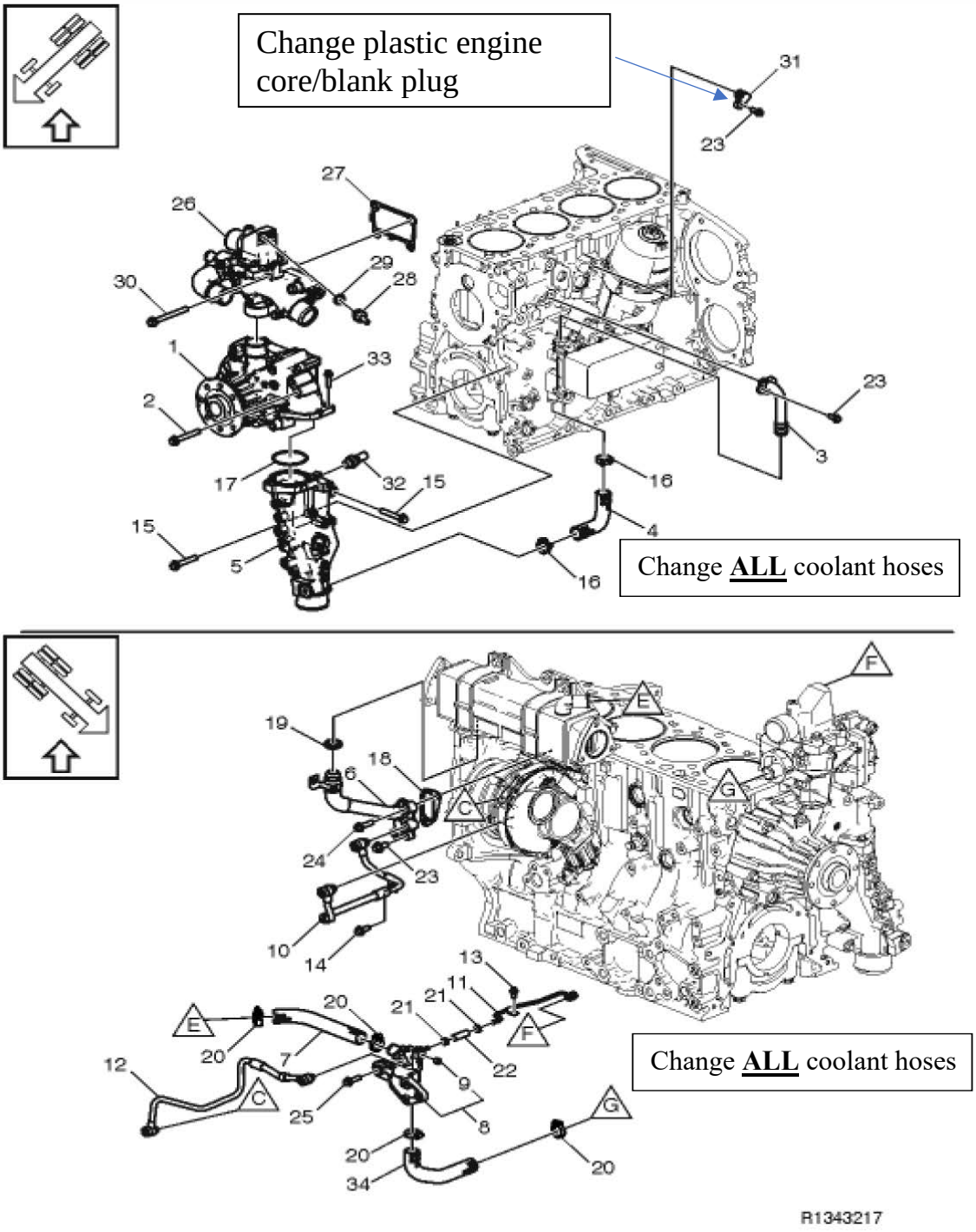
Section 1.2

Coolant pipes and hoses (Identity: TB-131763184-6)

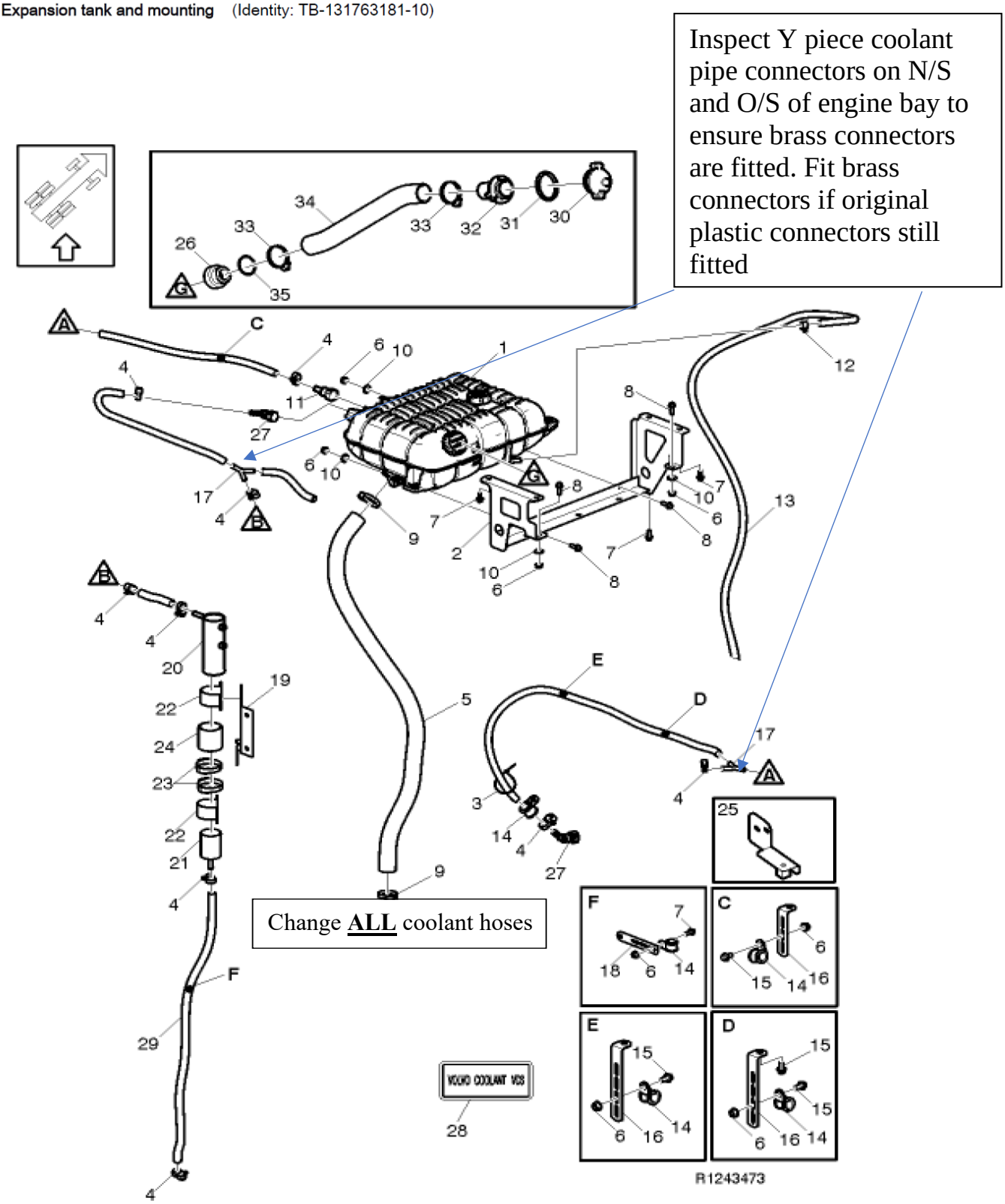
Change **ALL** coolant hoses



Coolant pump and thermostat (Identity: TB-134428021-6)

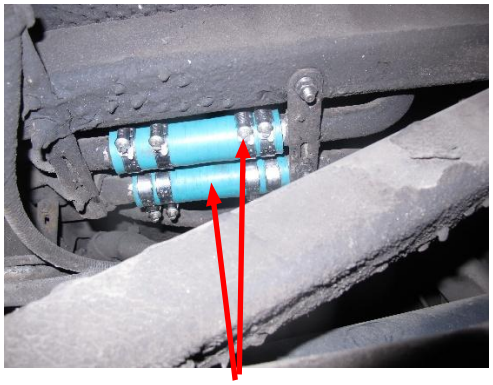


Expansion tank and mounting (Identity: TB-131763181-10)

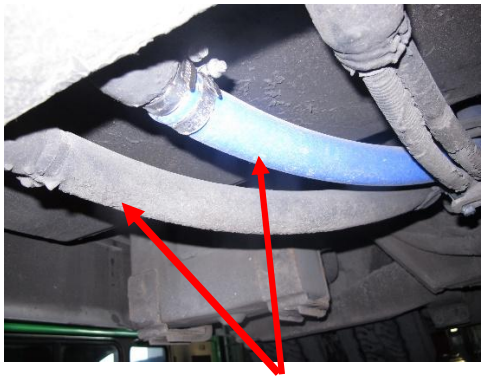


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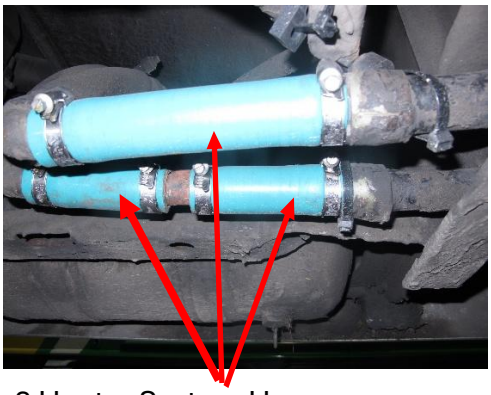
Section 1.2a



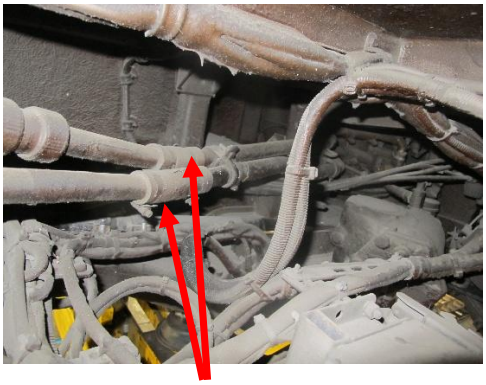
2 Heater System Hoses on Chassis Over Driveshaft.



2 Heater System Hoses on Chassis in front of O/R Wheels.



3 Heater System Hoses on Chassis - at Stairwell.



2 Heater System Hoses on Chassis - at Battery Box

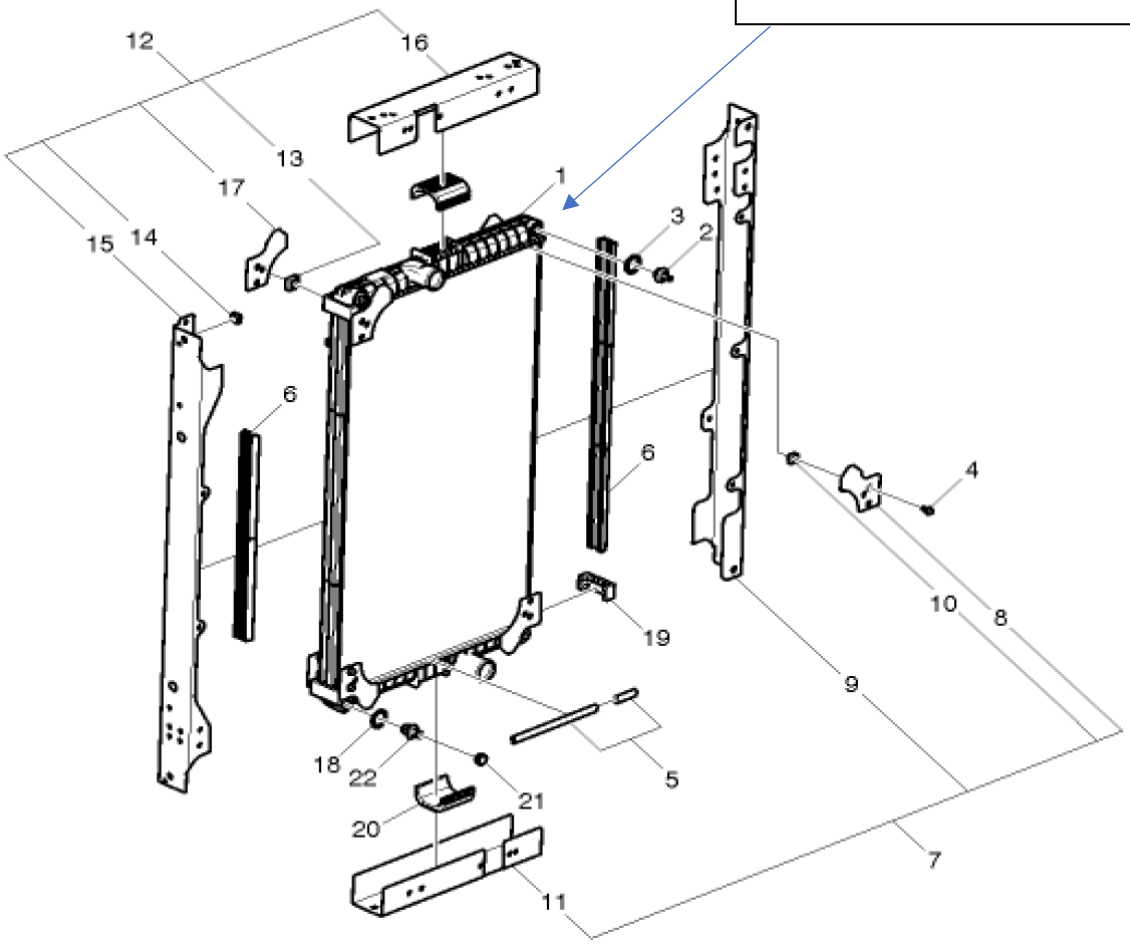


2 T-Shaped Hoses in Battery Box.

Section 1.4

Assembly (Identity: TB-131883787-1)

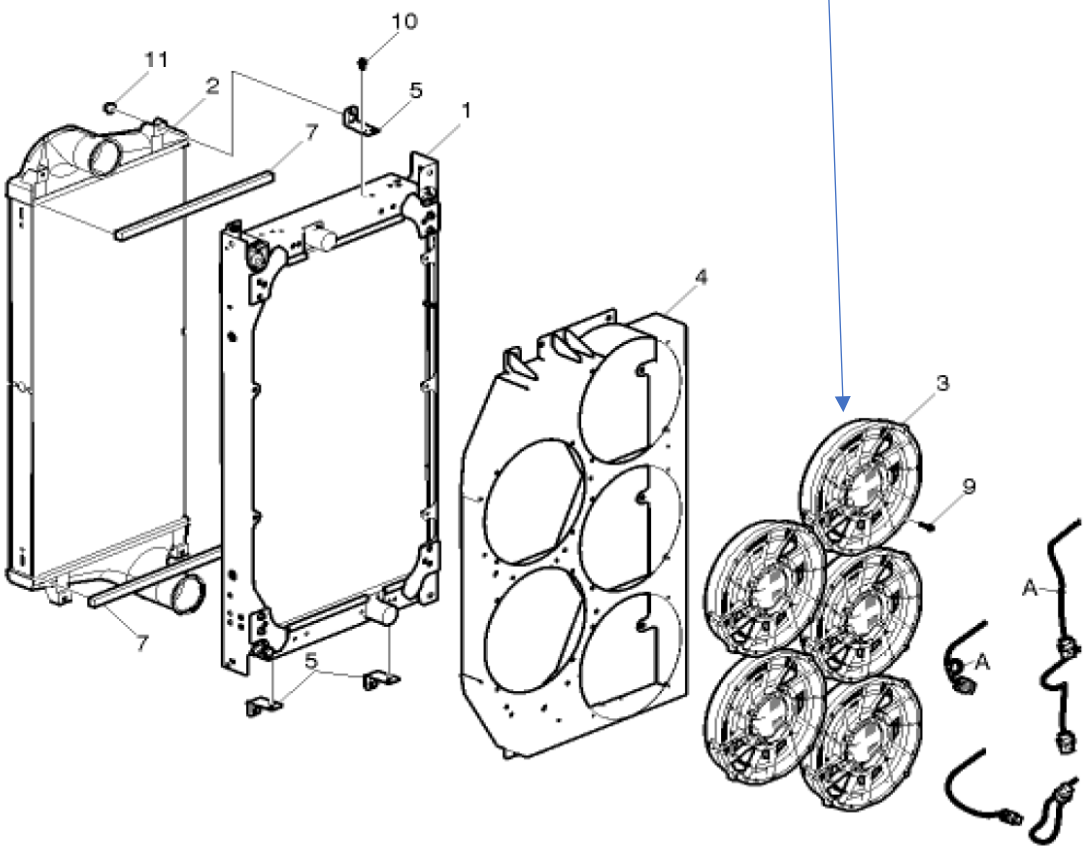
Change the cooling system radiator (latest Volvo part no.) and ensure all rubber cushions and mountings are present on installation.



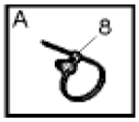
Section 1.5

Assembly (Identity: TB-133896707-1)

Change electric fan pack. Torque electric fan retaining bolts when fitting new fan. Inspect electric fan wiring loom and repair/replace where necessary.

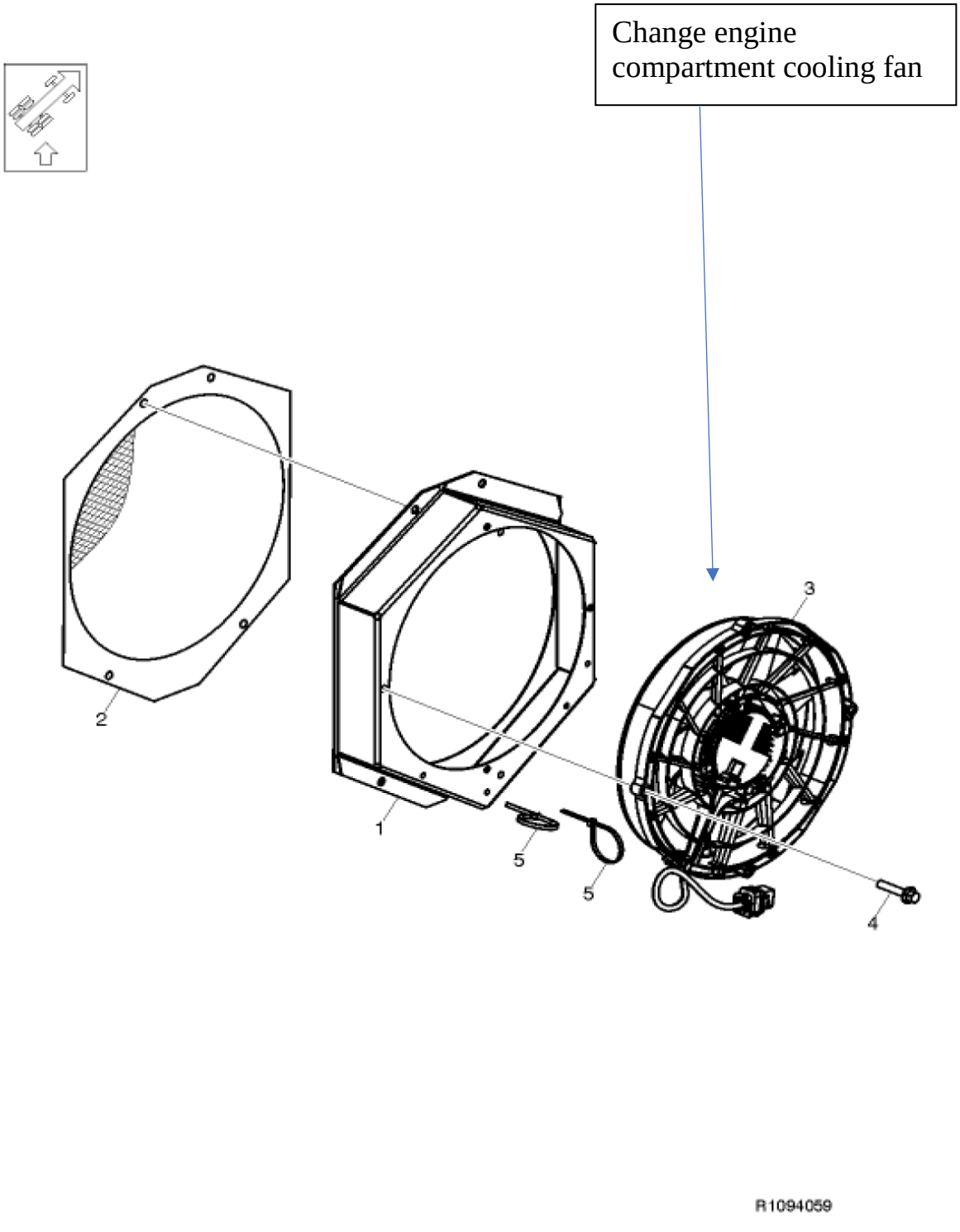






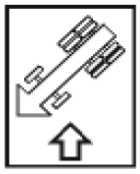
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Air ventilation (engine bay) (Identity: TB-132717544-1)

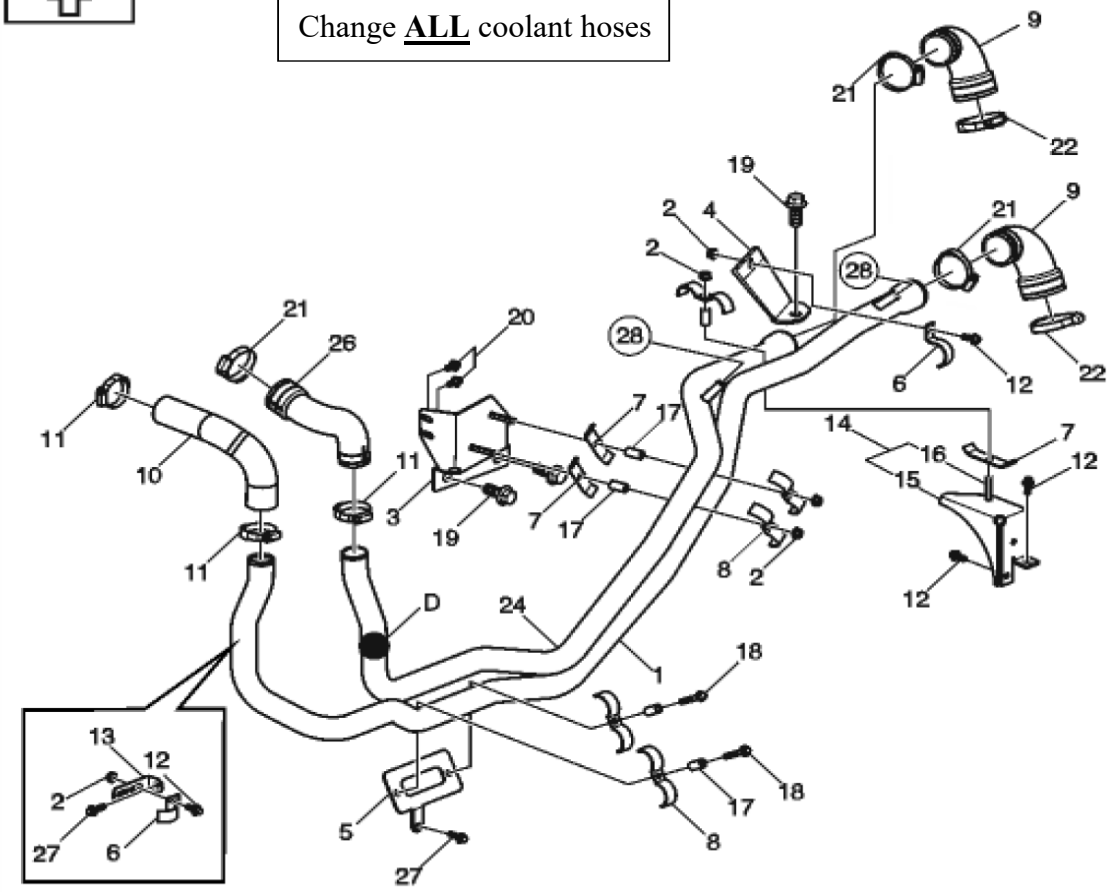


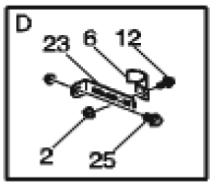
Section 1.7

Coolant pipes and hoses, hydraulic retarder (Identity: TB-131763264-4)



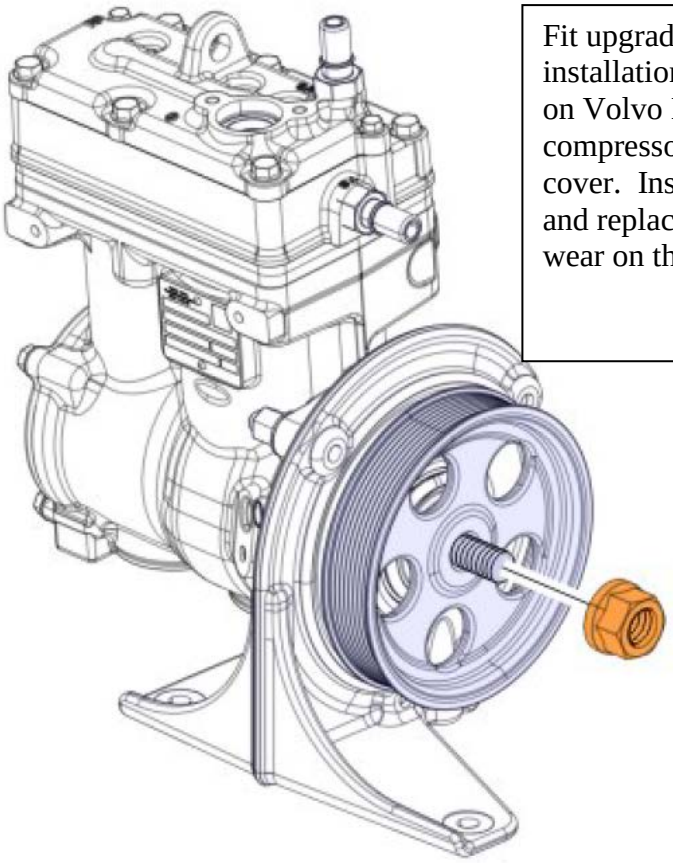
Change **ALL** coolant hoses



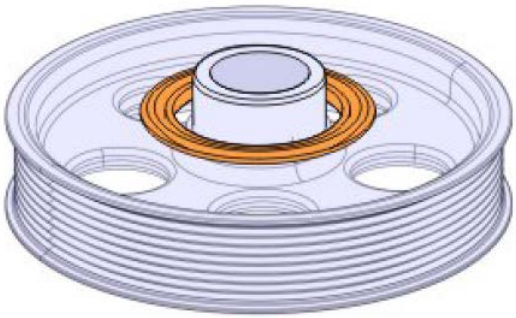


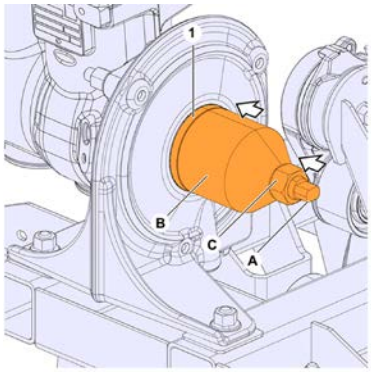
Inspect steel pipes 1,24 and replace where necessary. Ensure steel pipe clamping arrangements are in place. Replace and repair as necessary

Section 1.8



Fit upgraded compressor and installation kit as per instructions on Volvo IMPACT. Fit new compressor oil seal and dust cover. Inspect compressor pulley and replace if any indication of wear on the seal seat area.



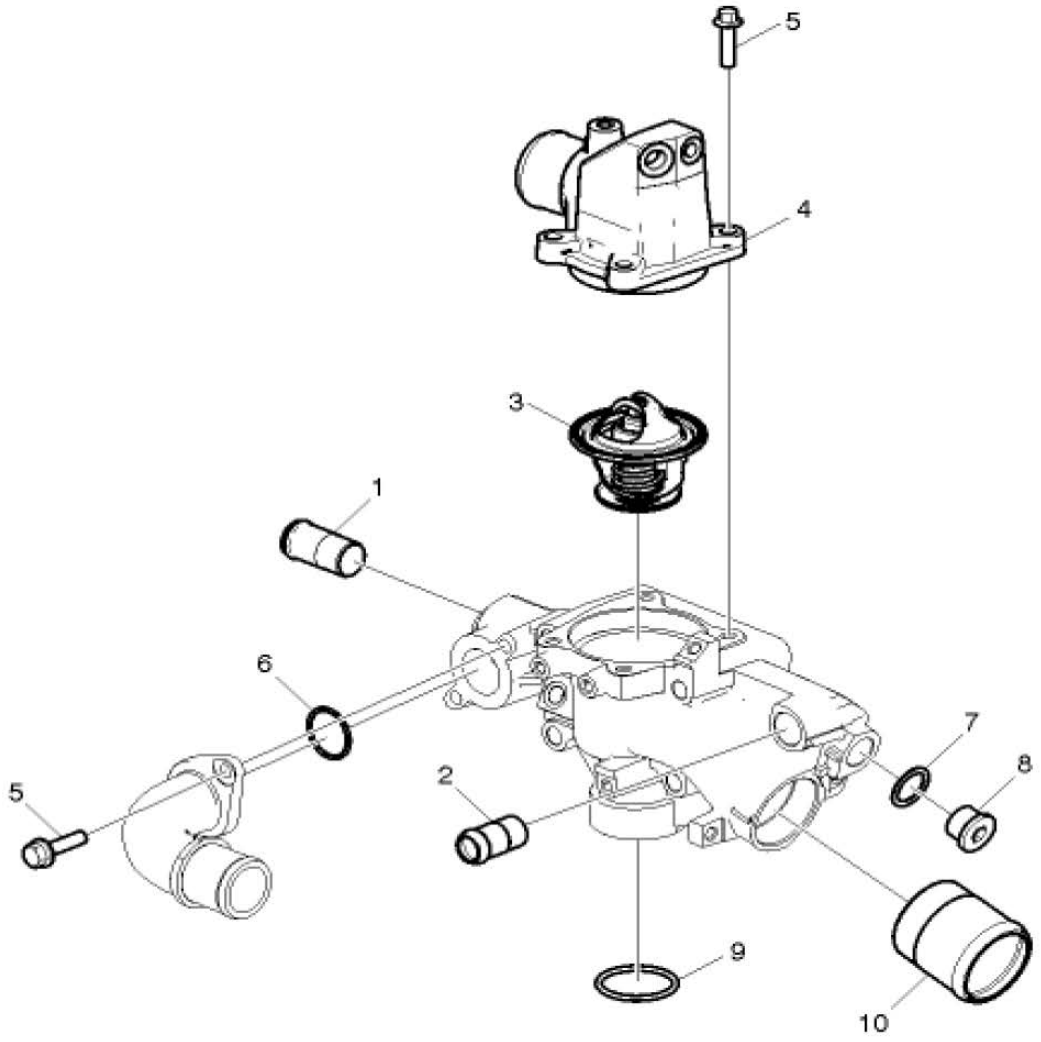


Fit the body (B) onto shaft (A) and fasten in place with nut (C).
To move and push the new oil seal ring (1). Tighten the nut (C) with a spanner.
Tighten the nut slowly until the seal ring has reached end position.

Section 1.9

Assembly (Identity: TB-136557941-1)

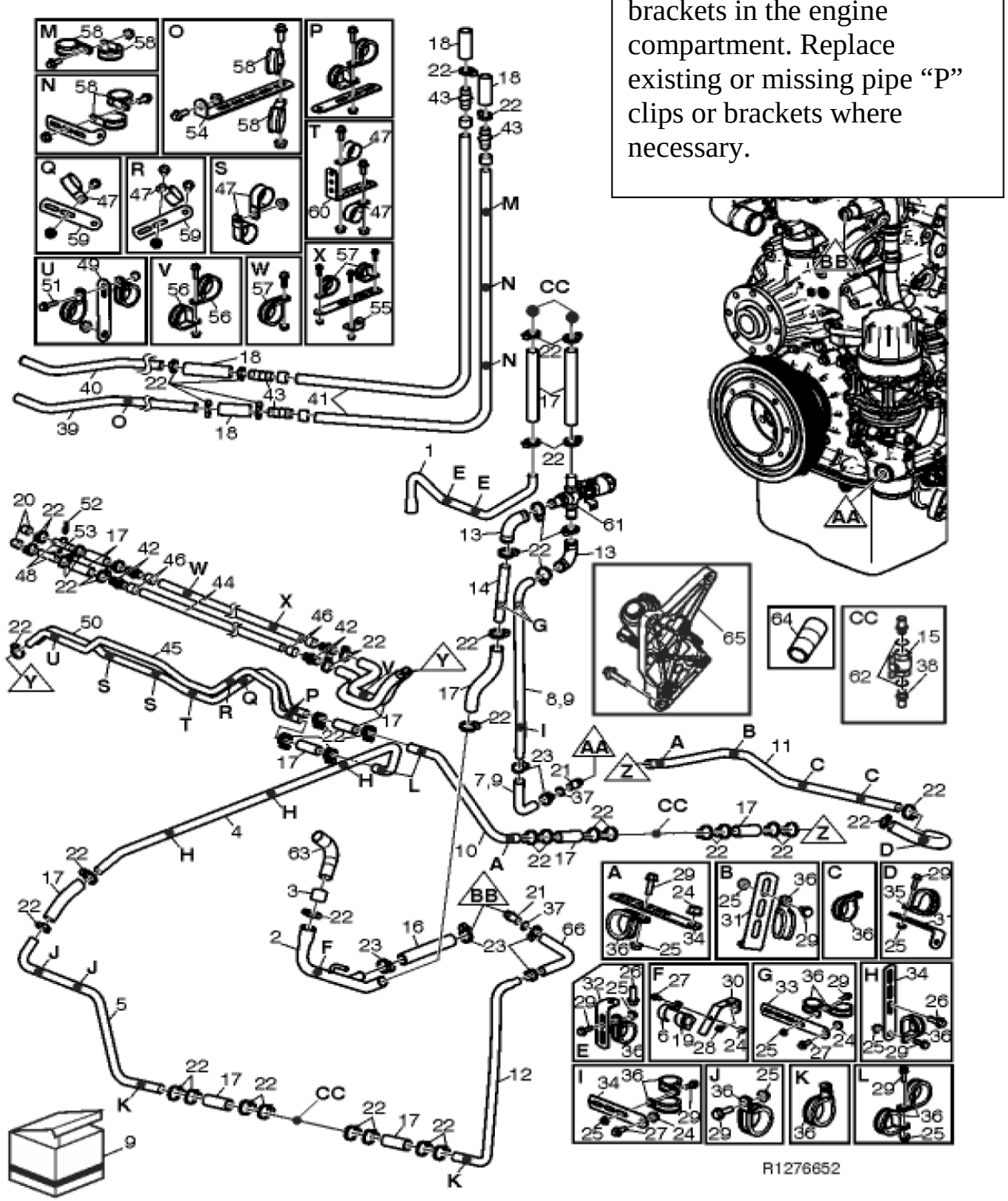
Change engine thermostat and seals.



Section 1.10

Heater piping (Identity: TB-133898430-7)

Replace all heating system flexible hoses in the engine compartment and replace existing clips with suitable constant torque clips. Inspect all heater pipe clips & brackets in the engine compartment. Replace existing or missing pipe “P” clips or brackets where necessary.



Section 1.11

Expansion tank and mounting (Identity: TB-131763181-10)

